

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval																																																							
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER :	
Misidentified ☐	Past Due ☐																																																														

Work Order ID 161560

Thursday, May 18, 2017 11:40:57 AM

161560

Page 2

Item ID: D022-720-011L02**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** R22 Cabin Floor Protectors - Black**Start Date:** 5/18/2017 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 5/26/2017 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Packaging

2

DAS
28
9-89

MAY 23 2017

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D022-720-011L02 / DSI 9545
Location: FG026

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.20

Quality Control

17/5/30

MAY 25 2017
MAY 25 2017

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Thursday, May 18, 2017 11:41:01 AM

Page 1

Work Order ID: 161560

161560

Parent Item: D022-720-011L02

D022-720-011L02

Parent Item Name: R22 Cabin Floor Protectors - Black

Start Date: 5/18/2017

Required Date: 5/26/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.03.02 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2854-1-100 *D2854-1-100*		Manufactured	No			110	Each	0.0000	4	8	**	162042 MAY 23 2017	
Velcro Strip, Looped													
D2854-3-100 *D2854-3-100*		Manufactured	No			110	Each	0.0000	4	8	**	162043 MAY 23 2017	
Hooked Velcro													
D3280-1L02 *D3280-1L02*		Manufactured	No			110	Each	2.0000	1	2	**	MAY 23 2017	
Floor Protector, LH													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST	2							
					159601	2							
D3280-3L02 *D3280-3L02*		Manufactured	No			110	Each	2.0000	1	2	**	MAY 23 2017	
Floor Protector, RH													
					<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>						
					ST	2							
					159602	2							

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐								
		OTHER : ☐							

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D022-720 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D022-720 REV. 0

REF TCCA STC: SH04-30
REF FAA STC: SR02037NY
REF EASA STC: EASA.IM.R.S.01074

PURPOSE:

To add the D022-720-011L08 Clear Cabin Floor Protectors. The -011L08 kit is similar to the existing -011 kit, however the plastic is transparent instead of solid black. The existing D022-720-011 kit will be re-identified as D022-720-011L02.

CHANGE:

The D022-720-011L08 Cabin Floor Protectors kit consists of two transparent plastic trays that are placed on the cabin floor to protect the carpets from damage. The -011L08 kit should be installed per the -011 kit of Installation Instructions IIN-D022-720 and maintained per Instructions for Continued Airworthiness ICA-D022-720. The parts list and weight & balance for the -011L08 kit is given below.

PARTS LIST

QTY -011L02	QTY -011L08	Part Number	Description
X		D022-720-011L02	Cabin Floor Protectors (Black)
	X	D022-720-011L08	Cabin Floor Protectors (Clear)
1		D3280-1L02	Floor Protector, Fwd LH, Black
	1	D3280-1L08	Floor Protector, Fwd LH, Clear
1		D3280-3L02	Floor Protector, Fwd RH, Black
	1	D3280-3L08	Floor Protector, Fwd RH, Clear
4	4	D2854-1-100	Looped Velcro Strip
4	4	D2854-3-100	Hooked Velcro Strip

WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D022-720-011L02 Cabin Floor Protectors	2.0 lb 0.91 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	100 in-lb 1.2 m-kg
D022-720-011L08 Cabin Floor Protectors	2.0 lb 0.91 kg	0 in 0 m	0 in-lb 0 m-kg	50 in 1.27 m	100 in-lb 1.2 m-kg

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161562-115
17-05-18

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 11.03.01
CERT. NO.: SH04-30
ISSUE NO.: 2

A	NEW ISSUE	CP	11.03.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9545	SHEET 1 OF 1
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR PROTECTOR KIT, CLEAR	NTS
DATE	11.03.01	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D022-720 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D022-720 REV. 0

REF TCCA STC: SH04-30

REF FAA STC: SR02037NY

REF EASA STC: EASA.IM.R.S.01074

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CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
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BY: *[Signature]*
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DATE: 11.03.01
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MFG. APPR.	N/A	DSI 9545	SHEET 1 OF 1
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DATE	11.03.01	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

120			
QC	Memo		0.06
Quality Control			



Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH04-30

Issue No.: 2

Approval Date: May 25, 2004

Issue Date: August 18, 2004

Responsible Office:

Ontario

Aircraft/Engine Type or Model:

ROBINSON R22 ALPHA, R22 BETA

Canadian Type Certificate or Equivalent:

H10WE

Description of Type Design Change:

Cabin Floor Protectors

**Installation/Operating Data,
Required Equipment and Limitations:**

Installation of Cabin Floor Protectors must be done in accordance with Dart Aerospace Ltd Installation Instructions IIN-D022-720, Rev. A, dated 04.04.06, or later approved revisions.

Maintenance of Cabin Floor Protectors must be done in accordance with Dart Aerospace Ltd Instructions For Continued Airworthiness ICA-D022-720, Rev 0, Transport Canada accepted 18 August 2004, or later Transport Canada accepted revisions.

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated will not adversely affect the airworthiness of the modified product.


Alex Pompei
For Minister of Transport